

Date: Wednesday, 26/11/2008 12:46:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WHEEL ASSEMBLY
Job Number : 43766	
Estimate Number : 12099	
P.O. Number :	Part Number : D3233041
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 43362	Material :
Written By :	Due Date : 03/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08.11.2008</u>	
Comment : Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by half K J/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32335	Hub Sleeve
-----	--------	------------

✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hub Sleeve

Pick:

Qty Part Number Description Batch

1 D3233-5 Hub Sleeve B43626

SAD

09-01-14

2.0	D32337	Shaft Sleeve
-----	--------	--------------

✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Shaft Sleeve

Pick:

Qty Part Number Description Batch

1 D3233-7 Shaft Sleeve B3764Y

SAD

09-01-14

3.0	D32339	Tire & Rim Assembly
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tire & Rim Assembly

Pick:

Qty Part Number Description Batch

1 D3233-9 Tire & Rim Assembly B43628

SAD

09-01-14

4.0	NKI 3020	BEARING
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✓



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

2 NKI 30/20 Bearing & Inner Sleeve M110310

SAD

09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 43766

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SHIM STOCK

.004" Brass Shim Stock



Comment: Qty.: 4.0000 f(s)/Unit Total: 16.0000 f(s)
.004" Brass Shim Stock

Pick:

Qty Part Number Description Batch

4 Shim Stock 0.004" thick Brass Shim Stock M102130

SAD 09-01-14

6.0

35X45X7

Bearing Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bearing Seal

Pick:

Qty Part Number Description Batch

2 35x45x7 Axel Seal

or CR 35x45x7 HMS4 R

M109645 (7)
M110232 (1)

SAD 09-01-14

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Press out bearings that are supplied with D3233-9 wheel and discard them.

Cut shims and assemble as per Dwg D3233

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.

SAD 09-01-14 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/15 (24)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST491

18 09/01/15 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 (1)

Job Completion



12 09/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

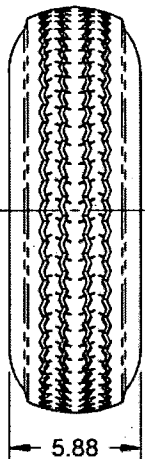
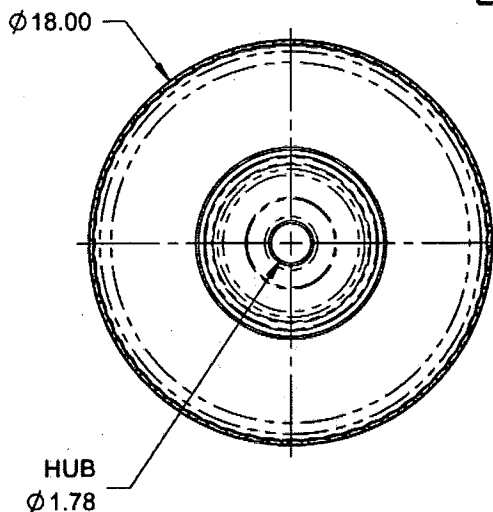
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



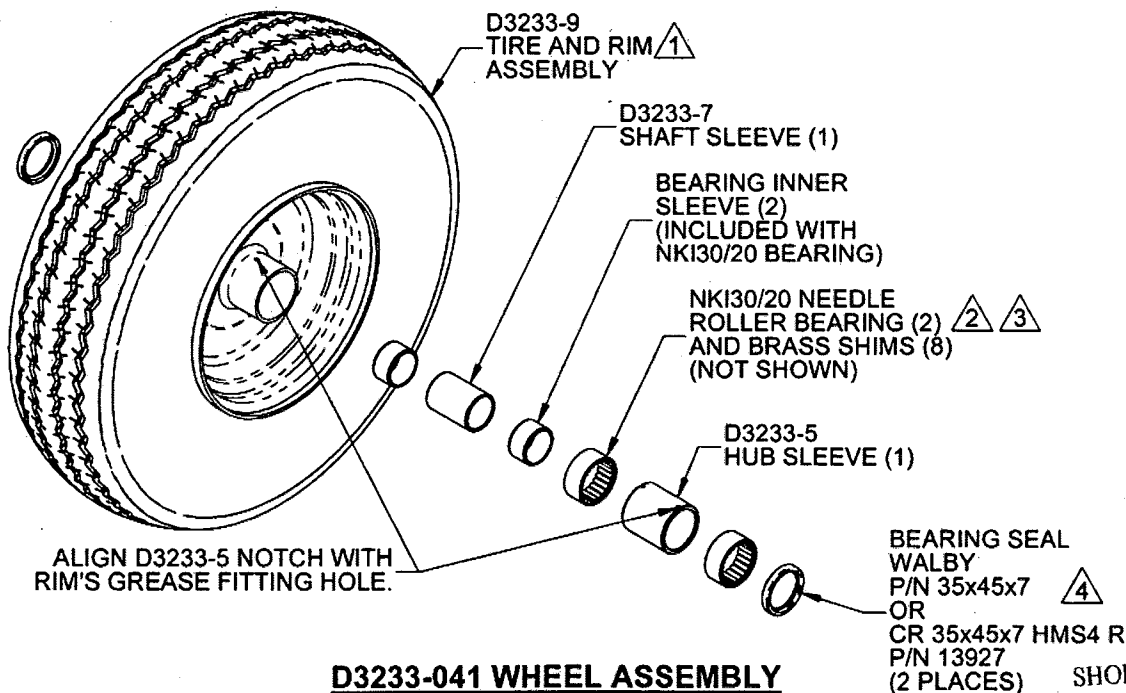
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
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05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

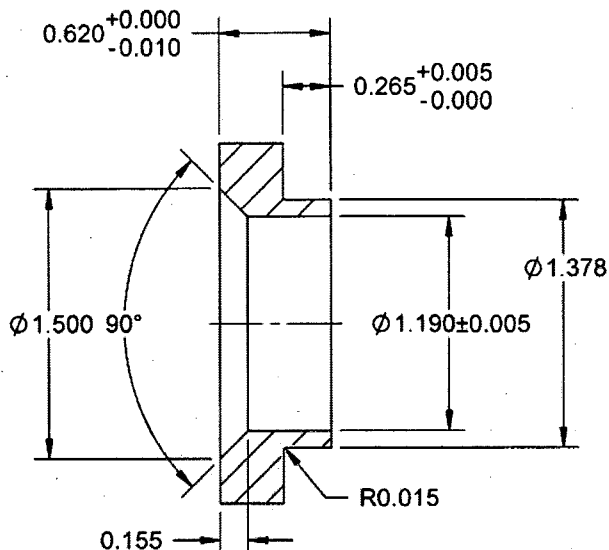
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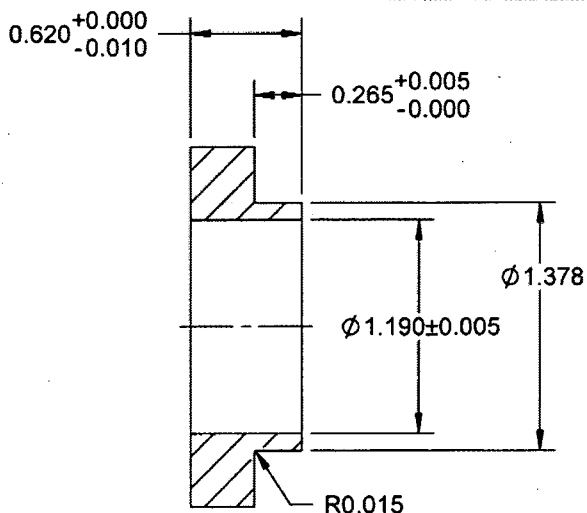
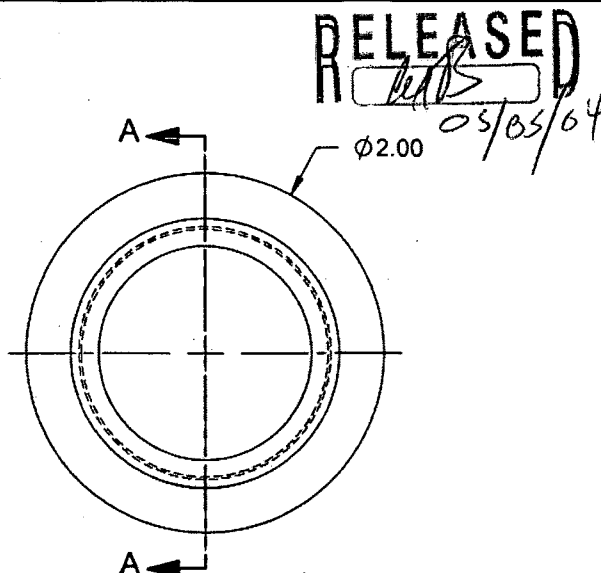


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



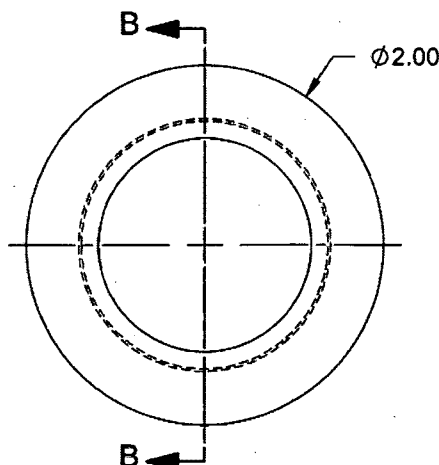
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A518-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. *43766*

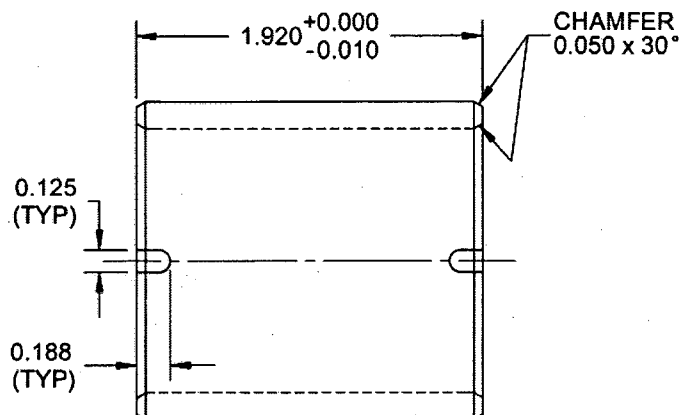
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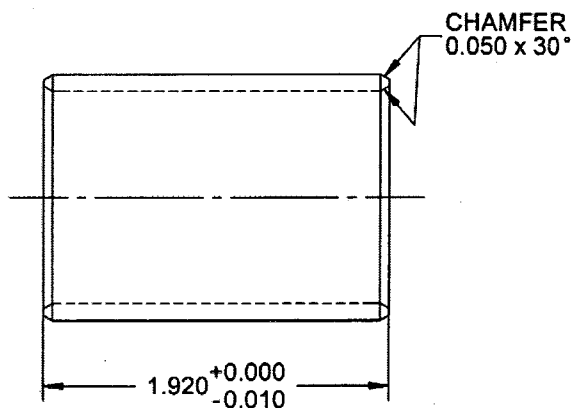
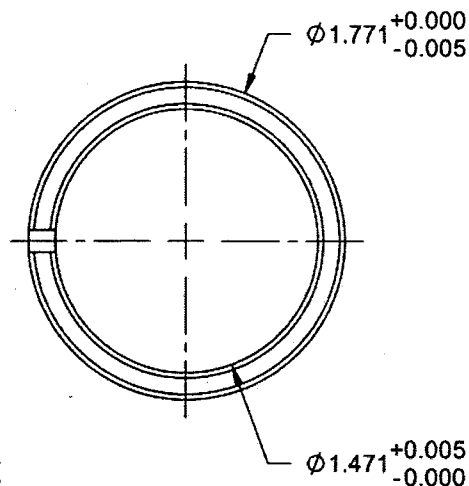


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

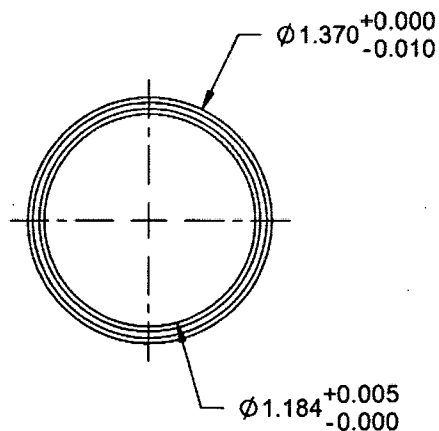
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05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ENGINEERING UNLESS OTHERWISE NOTED
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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